

Work Order ID 56787

Wednesday, March 10, 2010 8:36:53 AM



Page 1

Item ID: D3609-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 3/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 3/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 10-3-10 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3609

Rev A

0.00

100



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3609 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

MAT NOT PULLED

HB 10-3-10

6

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

HB 10-3-10

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

Sides 1/2

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56787

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Page 2

Item ID: D3609-1

Accept

Revision ID:

Item Name: Doubler

Start Date: 3/10/2010 Start Qty: 6.00

Required Date: 3/12/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 176

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Rec'd 3/11 *(6)*

10/03/10
ME
40-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 10, 2010 8:36:52 AM

Page 1

Work Order ID: 56787



Parent Item: D3609-1



Parent Item Name: Doubler

Start Date: 3/10/2010

Required Date: 3/12/2010

Comments: IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	34.3500	7.4331			



304/316 .032 Sheet



HB 10-3-10

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Main Warehouse

MAT

34.35

109023

32.45

109088

1.9

109057

109057

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

x **First Article**

Prototype

[illegible]

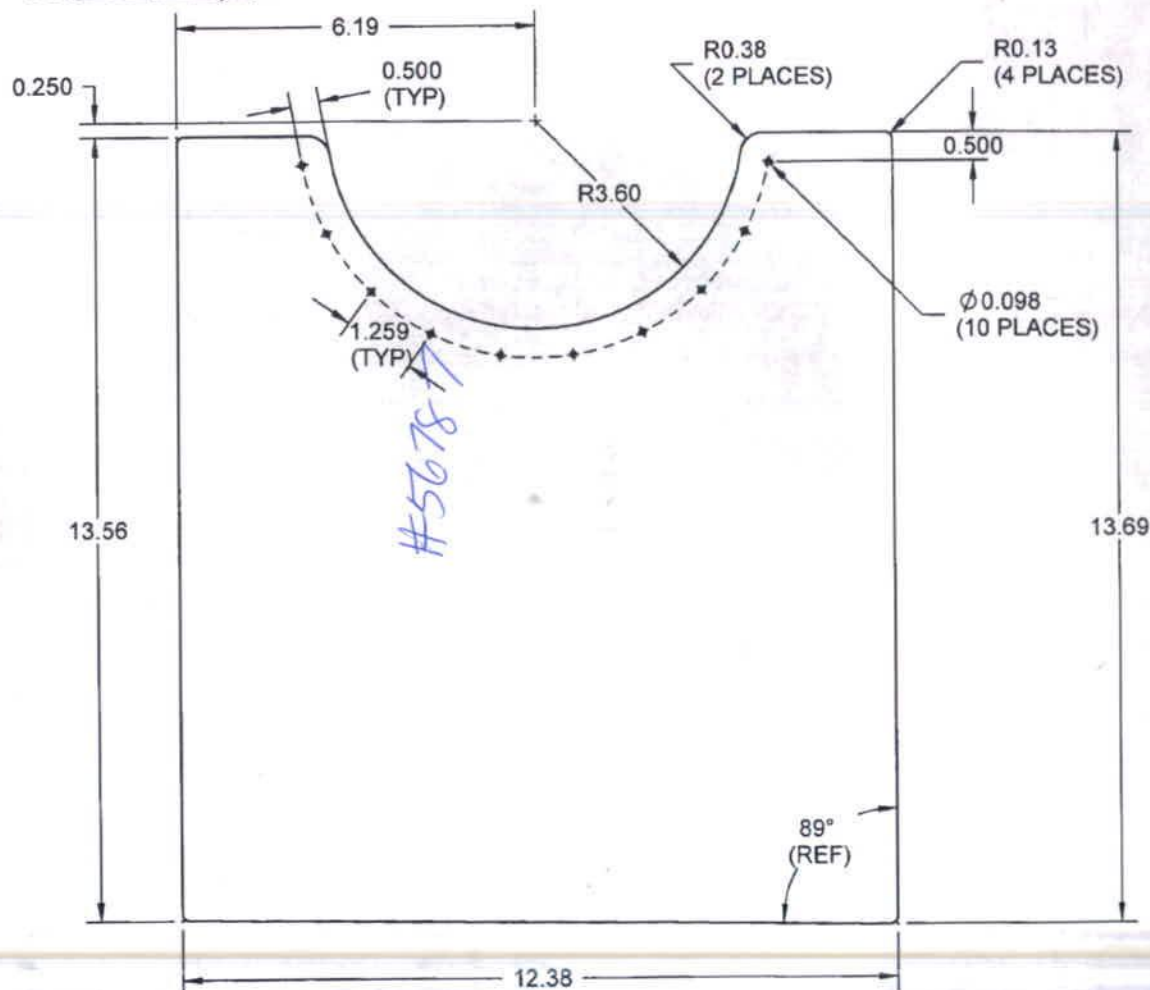
Measured by:	LB	Audited by:	S	Prototype Approval:	N/A
Date:	10-3-10	Date:	10/03/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





RELEASED
08/12/10 JH



NOTES:

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE
PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFY WITH DART P/N "D3609-1" USING FINE POINT PERMANENT INK MARKER
 - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
 - 7) PART IS SYMMETRIC ABOUT ϕ

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